

Date: Monday, 2/5/2007 4:02:32 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BAR
 Job Number : 30654
 Estimate Number : 10389
 P.O. Number : N/A Part Number : D31964
 This Issue : 2/5/2007 S.O. No. : N/A Drawing Number : D3196 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : 2/5/2007 Type : MACHINED PARTS Drawing Revision : U/R
 Previous Run : 29965 Material : N/A
 Due Date : 2/23/2007 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : J.F. 07.02.06
 Comment : Est Rev: A New Issue 05-11-08 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X01500 6061-T6 Bar .75" X 1.5"



Comment: Qty.: 3.0345 f(s)/Unit Total : 24.2760 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)
 (M6061T6B0.750x01.500)
 Identify for D3196-4
 Batch: M103321

J.F. 07/02/26

⑧

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank: (0.75" x 1.50") x 34.750" long Bar

J.F. 07/02/26

⑧

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3196-4 as per Folio FA339 and Dwg D3196 Identify as D3196-4

2-Deburr

J.F. 07/02/27

8

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/02/27

8

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 07/02/28

⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 03/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 4:02:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 30654

Part Number: D31964

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

yl

07/02/28x8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

yl

07/02/28x8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/3/02

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/3/04

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PC 07/03/05 (8)

Job Completion



U 07/03/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Bar		Part Number: D3196-4	
Inspection Dwg: D3196	Rev: <i>LC</i> <i>07.02.00</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.625	—			
33.650	+/-0.010	33.650	—			
16.639	+/-0.010	16.639	—			
0.488	+/-0.010	0.488	—			
0.962	+/-0.005	0.962	—			
0.464	+/-0.010	0.465	—			
0.504	+/-0.010	0.503	—			
Ø0.344	+0.006/-0.001	Ø0.348	—			
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	Ø0.665x108	✓			
0.512	+/-0.005	0.510	—			
0.060 x 45°	+/-0.010 x 0.5°	0.055x45°	—			
4.750	+/-0.010	4.750	—			
12.531	+/-0.010	12.531	—			
16.627	+/-0.010	16.627	—			
21.844	+/-0.010	21.844	—			
29.625	+/-0.010	29.625	—			
0.250	+/-0.010	0.250	—			
1.000	+/-0.010	0.999	—			
R0.125	+/-0.010	R0.125	—			
0.987	+/-0.010	0.987	—			

Measured by: <i>mf</i>	Audited by: <i>J.B</i>	Prototype Approval:	N/A
Date: 07/02/27	Date: 07/02/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev. updated	KJ/JLM <i>JA</i>	<i>BE</i>

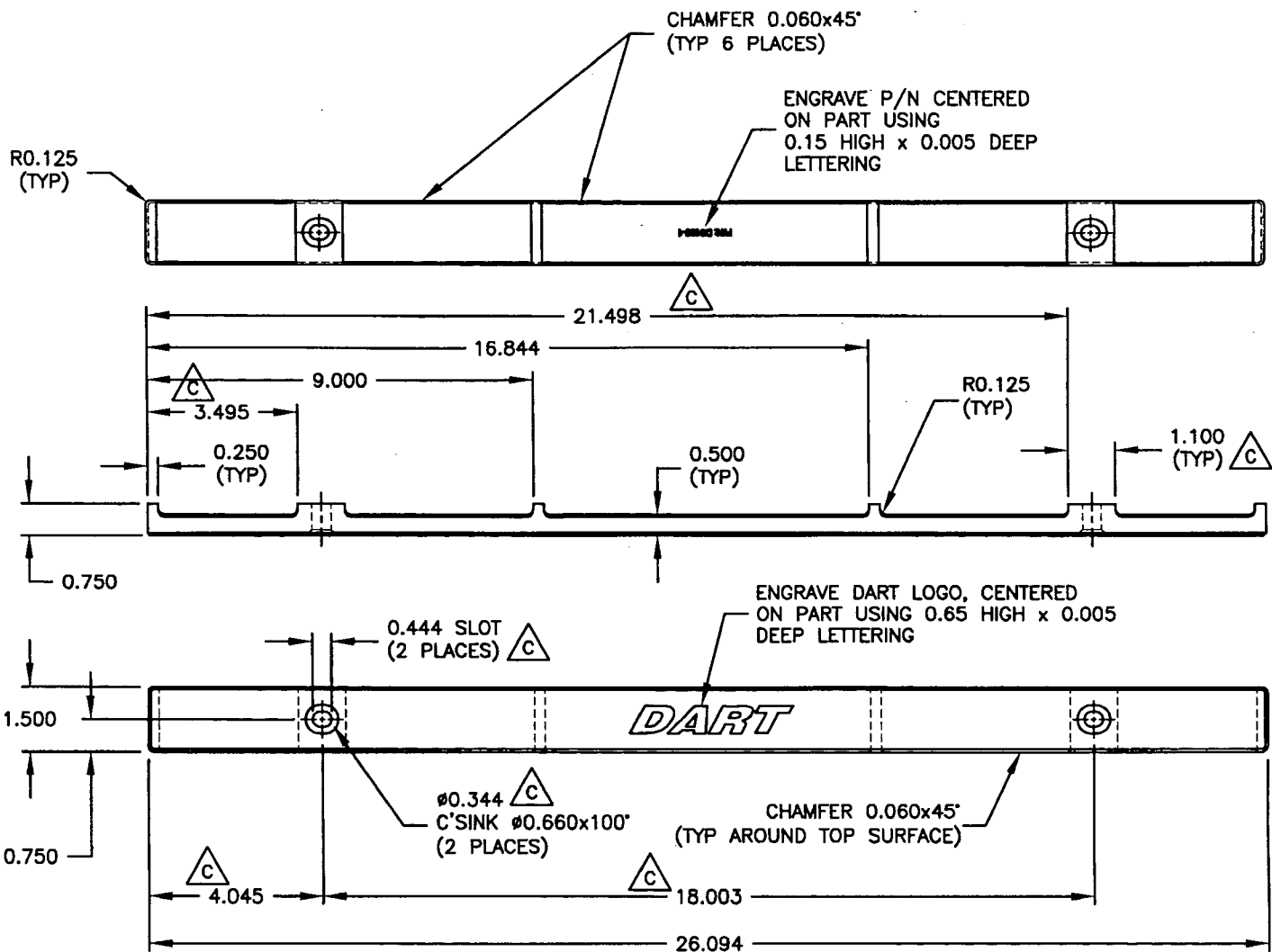
DART

RELEASED

06.10.31

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV. C
90	JS	D3196	SHEET 1 OF 3
CHECKED	APPROVED	TITLE	SCALE
PH	JS	BAR	1:4
DATE	06.10.31		
A	03.06.25	NEW ISSUE	
B	06.09.25	ADD D3196-5	
C	06.10.31	ADD SLOTS ON -1; REMOVED -5	

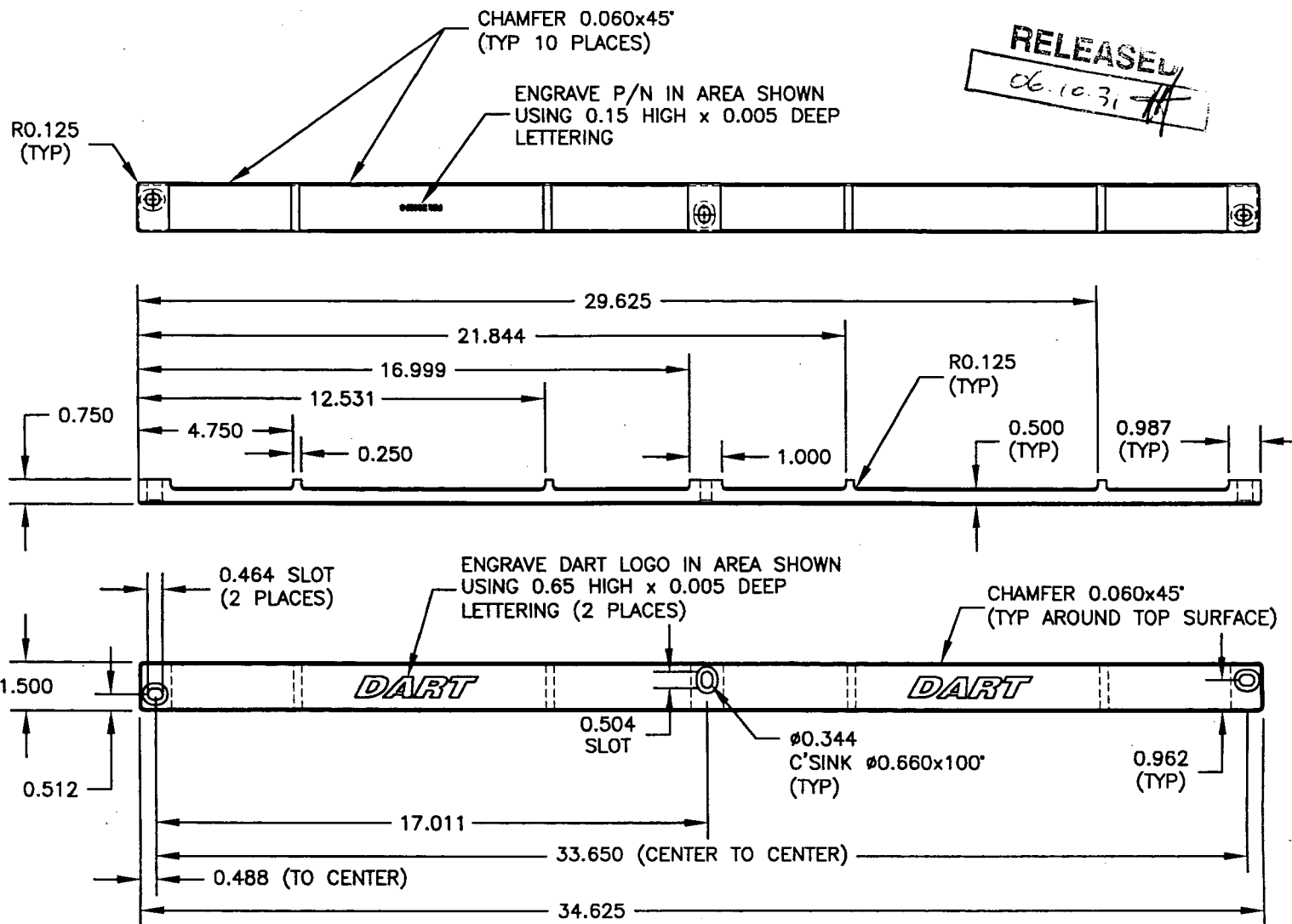
**D3196-1 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 30654



RELEASED
06.10.31



D3196-3 BAR

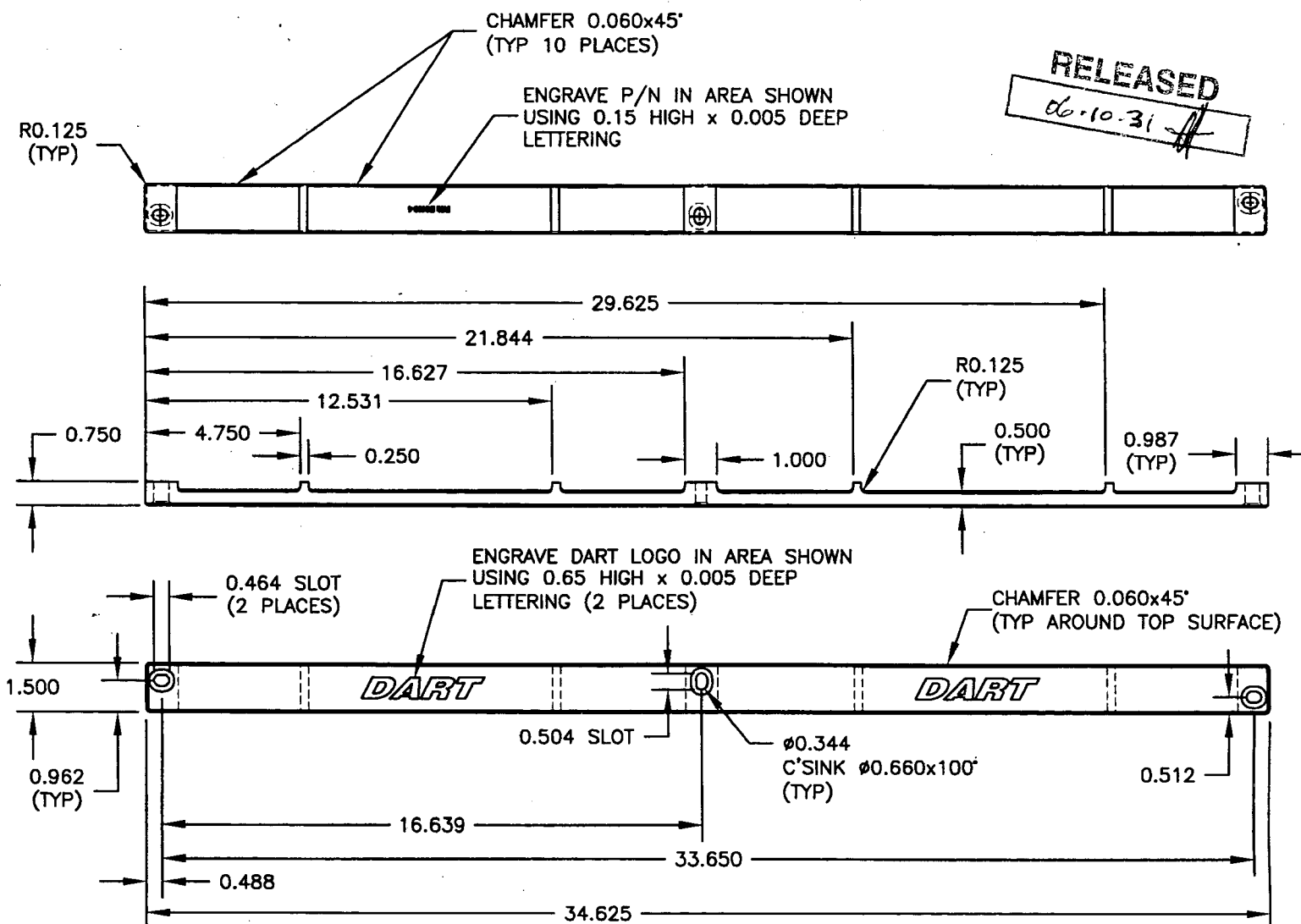
- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED PH	APPROVED [Signature]	HAWKESBURY, ONTARIO, CANADA
DATE 06.10.31	TITLE BAR	DRAWING NO. D3196
		SHEET 2 OF 3
		SCALE 1:5



RELEASED
06-10-31



D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE LTD
00		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH		D3196
DATE	TITLE	REV. C
06.10.31	BAR	SHEET 3 OF 3
		SCALE
		1:5